Work Order February-08-13 1				*968	85*			AS	AF	$\supset$	Page 1
Revision ID:	03171-1 .ngle			Accept	*N900	<u>1040</u>	100	)* s	Setup Star	1 11	S1* S2*
Start Date: 2/ Required Date: 3/ Reference:		art Qty: 10.00 q'd Qty: 10.00	*10* *10*		Cust Item Customer:		,			,	
			Date: 13 02 - Oc			Date:		R	Run Star Stop	1/1	R1* R2*
Sequence ID/ Work Center ID	Des	eration eription		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr									
D3171	Rev A										
*100 *100* Waterjet FLOW CNC Waterjet	FLO	OW WATER JET  Memo  1-Cut as per  Deburr if nec	Dwg D3171 Dwg Rev: essary	0.00  0.00  Prog Rev:	2-			14	٥	<u> </u>	ImB.3-8
*110	QC2	2- Inspect parts off ma	achine FAI/FAIB	0.00				14			~ 2 2 4
QC Quality Control		Memo		0.00					_6		Jm13-3-8
120	· QC8	3- Inspect parts - seco	nd check	0.00				سر		* •	DAS
*120* QC		Memo		0.00				(J.	13-13-	0 <u>3-05</u>	5 <b>09</b>

Quality Control

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Water Jet Engineering Skid-tube Crosstube Rework Prod. Eng. Coor. Quality Small Fab Machining Scrap Part No. Rec/Store/Packaging Other Thermoforming Finishing Use-as-is Supplier Large Fab Composite Work Order Update NCR No. Action Description of work order update Sign & Initial Root Verification Date QC Inspector **Chief Eng** Description Qty or Non-conformance Step Cause Date Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Grain Ovalized Bend Bending Temperature/Cure BOM/Route Over/Under tolerance Hardware Centre Not Concentric to O/S Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Maintenance Cuffs Contamination **Positioned Wrong** Mislabeled Heat Treat Countersink Power Loss/Surge Other Misread Cut Too Short Inspection Strip in Tube

Offset

Out of Calibration

Out of Sequence

**Outside Dimensions** 

**Drill Holes** 

Drawing

Finish

Folio

**Turning Sequence** 

Wave/Twist in Tube

Ripples in Bend

**Torque Waves in Extrusion** 

February-08-13 10:35:16 AM

Item ID: D3171-1 Revision ID:

Required Date: 3/08/13

Accept

\*N900040100\*

Setup Start

Item Name: **Start Date:** 

Angle 2/07/13

**Start Qty: 10.00** Req'd Qty: 10.00

\*10\*

Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N):

Date: \_\_\_\_ Tooling:

Date:

Date:

Run

Stop

									/
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
*130*	Small Fab								
Small Fab	Мето	0.00		5	B				
Small Fab	Deburr if necessary		1						
								*	

140

\*140\* Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

Bend as per Dwg D3171Tumble

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

Quality Control

Memo

0.00

(14) 13.03.08

2

											DQA:	[	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	COI	NFORM	/IANCE / UPI	DATE		QA Closed:		Date:	
Work Order					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Part No					Rework Skid-tube Crosstube Scrap Machining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite				Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	1	Initial nief Eng		ion ription		Sign & Date	Verificat	ion	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
					F	AUI	LT CATE	GORY						
EC	Bending Centre N Cracks Crushed Cuffs Heat Tre Inspection Ripples i Torque N	lot Conce /Crimped eat on Strip in n Bend Waves in S	n Tube Extrusion		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of S	ion Incomplete ions Incomplete/lenance eled d Calibration Sequence	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
, 1	Wave/T	wist in Tu	be	]	Folio	1	Outside	Dimensions						

February-08-13 10:35:16 AM

\*96885\*

Page 3

Item ID: Revision ID: Item Name:	D3171-1 Angle			Accept	*N900	<b>0401</b> 0	<b>)</b> 0*	Setup	Start Stop	14.71		
Start Date: Required Date Reference:	2/07/13 : 3/08/13	<b>Start Qty:</b> 10.00 <b>Req'd Qty:</b> 10.00	*10* *10*		Cust Item I Customer:	D:						
Approvals:	0.0	lan:		_		ate:			Start Stop	*NF *NI	२1* २2*	
Sequence ID/ Work Center I 160 *160* Packaging Packaging	ID	Operation Description Identify as per dwg & Sto	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool # Pla Co		pt Reje Qty		eject imber 7	Insp. Stamp	
170 *170* QC Quality Control		QC21- Final Inspection -  Memo	Work Order Release	0.00				MLJ	13-	-03-		

n (3.63.00

£> ·

Date:

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:														
Mork Orde		<u> </u>				DISPOSITION				AGAINST DE				
Work Orde	er: -					Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering	
Dort N	u.					Scrap	-		Machining Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
Part N	NO					Use-as-is	Thermoforming Finishing Rec/Store/Packaging Oth							
NCR N	No.					Work Order Update								
	_													
Root					Descri	ption of work order update	i	Initial	i	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data	Ш													
Equip/Tooling	Ш													
Operator	Ш		1											
Material	Ш		<u> </u>											
Setup			}											
Other														
Process												,		
Supplier					į									
Training														
Unapproved	П											<u> </u>		
						F	AUI	T CATE	GORY					
Landi	ing (	Gear				General		_			_			
	Г	Bending				Bend		Grain			Ovalized	_	Pressure/Forced	
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct _	Weld	
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Г	Cuffs				Contamination		Mainte	enance		Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Wrong		
		Inspectio		Tube		Cut Too Short		Misrea	d		Power Loss/	/Surge	Other	
		Ripples in				Drill Holes	Г	Offset			_			
		Torque V		Extrusio	n	Drawing		Out of	Calibration					
		Turning S				Finish		Out of	Sequence					
		Wave/Tv				Folio		Outside	e Dimensions					

## **Picklist Print**

February-08-13 10:35:23 AM

Work Order ID: 96885

D3171-1

Parent Item Name: Angle

\*96885\*

\*D3171-1\*

**Start Date: 2/07/13** 

Required Date: 3/08/13

**Start Qtv: 10.00** 

Required Qty: 10.00

Comments:

Parent Item:

IPP A02.11.04New IssueKJ

IPP Rev:B 08-03-27 now on water jet DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	269.7560	0.0206	0.216842			
*M304S16	$GA^*$								**	0.25	5		Jm13-3-6

304/316 Sheet .063

Location	Loc Qty	Loc Code	
MAT020	269.756		
122245	5.156		
123136	140.9		
124428	123.7		124428

Page 1

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE		QA Closed:		te:
Work Orde	or.					DISPOSITION			AG	AINST DE	PARTMENT	/PROCESS	
Part I	No					Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite					•	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause	l	Date	Step	Qty		or Non-conformance	Ct	nief Eng	Description		Date	Verificatio	n QC Inspector
Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							FAU	LT CATE	GORY				
Landi	ing G	iear		<del></del>	<del></del> -	General					· · · · ·		
		Bending Centre N Cracks Crushed/ Cuffs Heat Treat Inspection Ripples in	'Crimped at on Strip in n Bend	ı Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete cions Incomplete/Unclear enance eled d		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque V	Vaves in I	Extrusio	n	Drawing	].	Out of	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

DART AEROSPACE LTD	Work Order:	96885	
Description: Angle		Part Number:	D3171-1
Inspection Dwg: D3171 Rev: A			Page 1 of 1

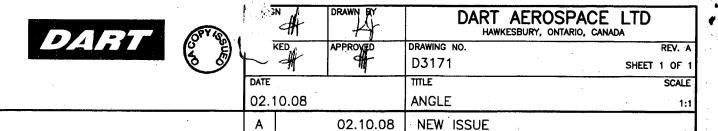
## FIRST ARTICLE INSPECTION CHECKLIST

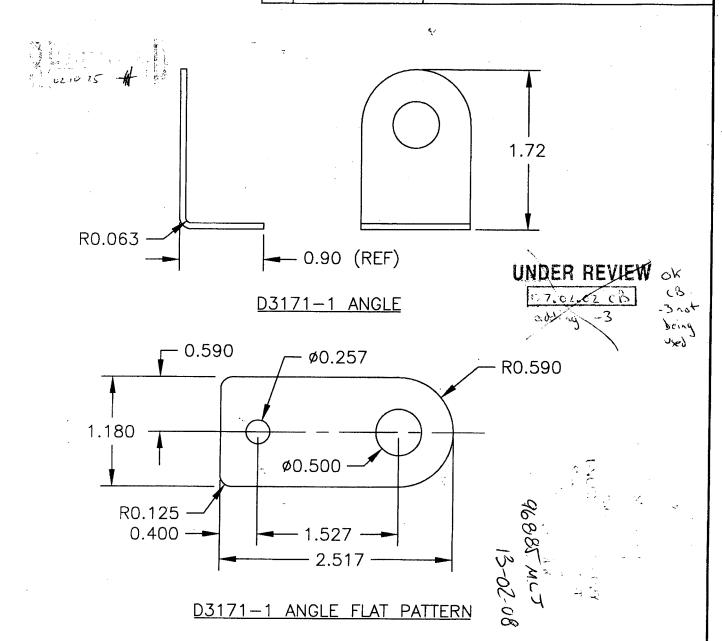
X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	0.500	_		V	Tomos
Ø0.257	+0.006/-0.001	0.257"	_		V	
2.517	+/-0.010	2.516"	_		U	
1.180	+/-0.010	2.516"	<b>~</b>		V	
1.527	+/-0.010	1.533"	_		ν	•
0.400	+/-0.010	0,402"			V	
0.590	+/-0.010	0.596"	_		V	
					***************************************	
					-	
					-	
			_			

Measured by:	Jm	Audited by:	. 09 /	Prototype Approval:	N/A
Date:	13-3-8	Date:	13.03.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.04.15	New Issue	KJ/DD	1
			- <del>', * </del>	





## NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK
- PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
  TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES 0.005 TO 0.010

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